



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBE350A93-3302-02
Job Sheet 189247



Part No: RBE350A93-3302-02

Job Qty: 5 pcs

Part Name: Tail Rotor Hub Lock Wrench



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3302-02 REV:11 IPP REV A 18.01.30 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	2/20/19	2/20/19	0.00	0.00	Start Up Small Fab-4		
100	Small Fab - 1	5 pcs	2/20/19	2/20/19	0.08	0.39	Small Fab - 1		
101	Small Fab - 2 - B4B	5 pcs	2/20/19	2/20/19	0.00	0.33	Small Fab - 1 - B4B		DAS 58 APR 23 2019 9-89
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
110	QC 5	5 pcs	2/20/19	2/20/19	0.00	0.00	QC 5 - 10		DAS 30 APR 3 2 2019 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	5 pcs	2/20/19	2/20/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B	68-6	APR 20 2019
				Packaging 3 - 9 - B4B	30	APR 20 2019
				Packaging 3 - 10 - B4B	SD	
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
140	QC 21 - FG	5 pcs	2/20/19	0.00 0.00	QC 21 - FG - 21	DAS APR 23 2019
					QC 21 - FG - 70	21
					QC 21 - SA - 53	9-85

Part Op **100** - -Small Fab - Assemble
 Descriptions: **110** - QC5- Inspect part completeness to step on W/O
130 - Identify as per dwg & Stock Location: 6A143B
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	20 Ea (4 ea)	90-Start up Operation	
90174A113	Retaining Pin	10 Ea (2 ea)	90-Start up Operation	
90177A218	Split Ring	20 Ea (4 ea)	90-Start up Operation	
90272A189	Machine Screw	5 Ea (1 ea)	90-Start up Operation	
94975A162	Quick Release Pin	5 Ea (1 ea)	90-Start up Operation	
CL-2-C	Lanyard Wire	8.3300 ft (1.666 ea)	90-Start up Operation	
RBE350A93-3302-02-1	Handle	5 pcs (1 ea)	90-Start up Operation	
RBE350A93-3302-02-3	Pin	10 pcs (2 ea)	90-Start up Operation	
RBE350A93-3302-02-5	Extension Handle	5 pcs (1 ea)	90-Start up Operation	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	20	500	0
	90174A113	10	73	0
	90177A218	20	116	0
	90272A189	5	163	0
	94975A162	5	22	0
	CL-2-C	8	226	0
	RBE350A93-3302-02-1	5	7	0
	RBE350A93-3302-02-3	10	23	0
	RBE350A93-3302-02-5	5	17	0
Part Specifications				
Specifications could not be found.				

Plex 4/23/19 8:52 AM Dart.Hadley.Shannon

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RBE350A93-3302-02
Job Sheet 189247



Part No: RBE350A93-3302-02

Job Qty: 5 ea

Part Name: Tail Rotor Hub Lock Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/8/19 Feb 20!

Created By: Marie Lajeunesse

Type: Stock SOLD

Description:

Note: DWG RBE350A93-3302-02 REV:11 IPP REV A 18.01.30 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	2/8/19	2/8/19	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	5 pcs	2/8/19	2/8/19	0.08	0.33	Small Fab-9		
110	QC	5 pcs	2/8/19	2/8/19	0.00	0.00	QC5		
130	Packaging	5 pcs	2/8/19	2/8/19	0.00	0.00	Packaging3-2		
140	QC21-FG	5 Ea	2/8/19	2/8/19	0.00	0.00	QC21		

Part Op 100 - Assemble
Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31 62028	Ferule 1/16 X 3/8" - Aluminum	20 Ea (4 ea)	90-Start up Operation	5161581
90174A113	Retaining Pin	10 Ea (2 ea) 5143041	90-Start up Operation	5039354 505072
90177A218	Split Ring	20 Ea (4 ea)	90-Start up Operation	5054399
90272A189	Machine Screw	5 Ea (1 ea)	90-Start up Operation	5039348
94975A162	Quick Release Pin	5 Ea (1 ea)	90-Start up Operation	5039347
CL-2-C	Lanyard Wire	8.3300 ft (1.666 ea)	90-Start up Operation	5039348
RBE350A93-3302-02-1	Handle	5 pcs (1 ea)	90-Start up Operation	51137090 5164402
RBE350A93-3302-02-3	Pin	10 pcs (2 ea)	90-Start up Operation	51621836 5163181
RBE350A93-3302-02-5	Extension Handle	5 pcs (1 ea)	90-Start up Operation	5149060

Job Allocation



Container No: S174026



Part: RBE350A93 - 3302 - 02

Job No: 189247

Serial No/Batch: S174026

Revision: 11

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Required	Inventory	Allocated
20	618	0
10	19	0
20	112	0
5	174	0
5	18	0
5	493	0
5	8	0
10	14	0
5	1	0

Date: 04/22/19

Plex 1/22/19 10:23 AM Dart.lajeunesse.marie

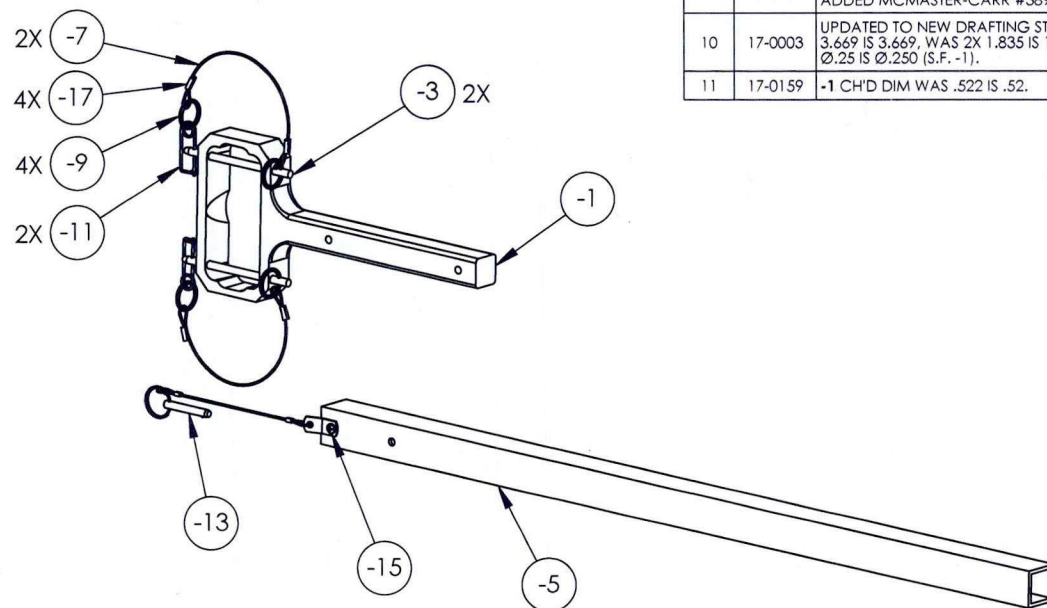
Part Specifications

Specifications could not be found.

Plex 1/22/19 10:23 AM Dart.lajeunesse.marie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 CH'D INSIDE ANGLED RADIUS FROM R.75 TO R.375, CH'D DIM WAS 1.122 IS 1.	12/5/2008	WP	DW
2		-1 ADDED Ø.250 HOLE. -5 ADDED #8-32 HOLE & Ø.250 HOLE.	3/18/2009	WP	DW
3		-1 ADDED 1 INCH SQUARE DIM, CH'D DIM TO 2.309. -5 CH'D OD & ID DIMS.	4/29/09	RJC	
4		-5 DELETED ENGRAVE NOTE.	6/1/2009	RJC	
5		-1 ADDED TOLERANCE 1.00 - .98 TO HANDLE. -3 SHORTENED PIN BY 3/8 ON BOTH ENDS. -5 EXTENDED FROM 1.61 TO 30.0, MOVED PIN HOLE FROM 1.25 TO 3.00, CH'D MATERIAL WAS STEEL IS ALUMINUM.	10/6/2009	WP	DW
6		-1 CH'D TOOLING HOLE WAS Ø.266 IS Ø.250, ADDED ENGRAVE NOTE. -5 ADDED ENGRAVE, CH'D TOOLING HOLE WAS Ø.266 IS Ø.250.	12/16/2010	RJC	RW
6A		-5 CH'D TUBE WALL THICKNESS WAS .105 IS .125.	5/10/2012	RJC	GEB2
7		-1 CH'D DIM WAS Ø.250 IS Ø.250 +.005 -.000.	4/18/2013	CFS	JG
8A		CORRECTED T/N WSS RBEA93-3302-02 IS RBE350A93-3302-02.	11/5/2013	RJC	RW
9	15-0131	-7 CH'D WAS MCMASTER-CARR #30345T1 5 IS CARR LANE #CL-2-C. -9 CH'D QTY. WAS 2 IS 4. -17 ADDED MCMASTER-CARR #3896T31.	6/12/2015	RJC	JAG
10	17-0003	UPDATED TO NEW DRAFTING STANDARD. -1 CH'D DIM WAS 3.071 IS 3.07, WAS 5.315 IS 5.32, WAS 2X 3.669 IS 3.669, WAS 2X 1.835 IS 1.835, WAS 4X .190 IS 2X .190. ADDED DIM .522. -3 CH'D DIM WAS Ø.25 IS Ø.250 (S.F. -1).	2/28/2017	RJC	SM
11	17-0159	-1 CH'D DIM WAS .522 IS .52.	6/21/2017	RJC	JAG



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WITHOUT NOTICE
WORK ORDER

NO. 189247 MLS
19-01-22

NOTE:
ORIGINAL No. REF: RBEA93-3302-2 = 350A93-3302-02.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	HANDLE	6061		2
			-3	2	PIN	S.S.		3
			-5	1	EXTENSION HANDLE	ALUMINUM SQ. TUBE		4
		B/O	-7	2	LANYARD	COATED STEEL	Ø1/16 X 8 7X7 CABLE (CARR LANE #CL-2-C)	1
		B/O	-9	4	SPLIT RING	STEEL	Ø1 O.D. X 1/8 (MCMASTER-CARR #90177A218)	1
		B/O	-11	2	WIRE LOCKING PIN	STEEL	Ø1/16 X 1-1/16 USABLE (MCMASTER-CARR #90174A113)	1
		B/O	-13	1	QUICK RELEASE PIN W/LANYARD	S.S.	Ø1/4 X 1.3 USABLE (MCMASTER-CARR #94975A162)	1
		B/O	-15	1	MACHINE SCREW	STEEL	#8-32 UNC-2A (MCMASTER-CARR #90272A189)	1
		B/O	-17	4	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896T31)	1

DART AEROSPACE	
TITLE T/R HUB LOCK WRENCH	
DWG NO. RBE350A93-3302-02	REV 11
MAT'L TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL EUROCOPTER 350/355	
DRAWN BY: PERRITT CHECKED: DUERFELDT OPSS APPR: ANDERSON QA APPR: LINDSAY APPROVED: MACKOVJAK	SCALE 1:6 DATE 10/20/2008 SHEET 1 OF 4

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART
AEROSPACE

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Container No: S174026

Part: RBE350A93-3302-02

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Date: 04/23/19